84900

Page 1

May-29-12 2:49:39 PM Item ID: D209-669-043 Accept *N900040100* Setup Start Revision ID: Item Name: Replacement Skidtube **Start Date:** Start Qty: 1.00 29/05/2012 **Cust Item ID: Required Date:** 16/07/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: MLJ Date: 12/05 79 Tooling: Approvals: QC: Date: Sequence ID/ Operation Tool # Plan Reject Reject Accept Insp. **Work Center ID** Description Code Qty Oty Number Stamp Draw Nbr **Revision Nbr** D2906 Rev B 100 0.00 DOCUMENT CONTROL *100* DC Memo 0.00
Photocopy D209-669 bluefile & type labels per PPP D205-669-043 Chg 102 fer ECN 12-597 Document Control 110 0.00 Skidtubes *110* Skidtubes 0.00 Memo 1206-20 SAO Skidtubes - Inspect mat'l D2500-1-190 for damage -Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid) -Open holes to 0.500" as per Dwg D2906 without cutting fluid -Deburr and blow out all chips from

-Acid etch and Alodine tube per QSI 005 4.1

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W/O:			WORK ORDER CHANGES							
DATE	STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval of QC Inspector	
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								€ I		
Dart No	·• ·	DAD #.	Fault Catagory		NOD. Vas	No DO	١	Deter		

	Resolution:			53.289				
NCR:		We		DER NON-CONFORM	ANCE (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sect Action Description Chief Eng	Sign & Section C		Approva	
12 (old 20	中 100	14th how Driven b .570th Shows he R 500" R-C Drive towston in employed hand, operation employed	RIN	THE TOTAL STREET		12041	10 poopsi	
		Front Front (Forward) of tube #7 hole						
							,	

Item ID: Revision ID:	D209-669-0	,		Accept	*N900	040)* 5	Setup S		*N	S1*
	Replacement : 29/05/2012 16/07/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:	ID:				top	*N:	S2*
Approvals:		in:	Date:	Tooling: SPC (Y/N):		ate:		F		tart top	*N *N	R1* R2*
Sequence ID/ Work Center II 120 *170* QC Quality Control		Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp
*1304 *130* Skidtubes Skidtubes		Pick: Qty Part Nu A/R Sikaf Sikaflex expi Start Time: Fin Time: pick: Qty	mber Description Ba		e cutting							

DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
							<u>.</u>

NCR: 12	-1691	W	ORK OR	DER NON-CONFORMANCI	E (NCR)	\$ 13	00.85	·	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
12 bolut	100	Found when always take In horry gush on the Bottom about 85,250" From Atr. locks to be at leas 0.060" Deep. (See attract p.c's) R-C. Packagin Supplier	N. C.	SCRAP + Destry take	76 128-14	5AD 12-08-14	15/10/14 32.	0AS 166 17/05/14	
								· .	

Quality Control

May-29-12 2:4	9:39 PM					,,,,,							
Item ID: Revision ID:	D209-669-0)43			Accept	*N900	0040	1100) * s	Setup Sta	rt *N	S1*	2.5
Item Name:	Replacement	Skidtube								Sto	op *N	S2*	
Start Date:	29/05/2012	Start Qty:	1.00	*1*		Cust Item	ID:						
Required Date:	16/07/2012	Req'd Qty	: 1.00	*1*		Customer:							
Reference:				•									
Approvals:	Process Pla	an:	Date:		Tooling:	D	ate:	- 	F	Run Sta	171	R1*	
	QC:		Date:		SPC (Y/N):	D	ate:			Sto	^p *N	R2*	
Sequence ID/ Work Center II	D	Operation Description	1	· · · · · · · · · · · · · · · · · · ·	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
140		. DEVENOUGH			0.00					•	- ·	•	
*140**			ACHINE - CROSSTU	BES									
CNC Bend 1 CNC Delta 100 Ben	dor		lemo	CODATEUD 6	0.00	l IET em							
ene bena 100 ben	dei				COBRAFT on CNC Be	nder and Folio F1							
		2-	-Cut tubes as per Dwg.	D2906									
150	•	Skidtubes	\		0.00					i			
Skidtubes		М	lemo		0.00					·			
Skidtubes		-E	Deburr ends and remove	ve markes from	bending								
		ar	nd dwg. Hold x-bolt wi	th DT9701 Use	QSI002 and trim/ grind flet tube expander 1/2 x170 achieve dwg dimention.	ush per QSI002 G to start							
160		QC5- Inspect p	part completeness to st	ep on W/O	0.00								
160													
QC		М	lemo		0.00								

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W/O:			W	ORK ORDER CHANGE	S				P.
DATE	STEP	PROC	EDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval · QC Inspector
							<u> </u>		
		PAR #:	_ Fault Cat	egory:	NCR: Yes	No DQ	A:	_ Date: _	
	Resolution:		_ Dispositi	on:	QA: N/C CI	osed:		Date: _	
NCR:		W	ORK ORI	DER NON-CONFORMAN	ICE (NCR)			
6470		Description of NC		Corrective Action Section		Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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	Work Order ID 84900 May-29-12 2:49:39 PM			*84900*						P			
Item ID: Revision ID:	D209-669-04	43	11 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	Accept	*N900	040) * :	Setup Sta	1/7	S1*		
Item Name:	Replacement	Skidtube							Sto	^{'p} *N	S2*		
Start Date: Required Date Reference:	29/05/2012 : 16/07/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:	ID:							
Approvals:	Process Pla	n:	Data	Taoling			-	I	Run Sta	rt *N	R1*		
rippi ovais.						ate:			Sto		R2*		
Sequence ID/ Work Center I	D .	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp		
170 Skidtubes		Large Fab		0.00						·			
Skidtubes			for wearplates using D eb.Deburr	T8217 Open holes to 19/64",	adjust stopper								
		-Drill pilot	holes for aft & fwd cap	using DT8215 open holes t	to #6" Deburr								
		-Drill pilot	holes for Tow ring usin	g DT8091-3 , open to .640	"and Deburr								
190		QC5- Inspect part comp	leteness to step on W/C	0.00									

0.00

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190

Quality Control

W/O:			WO	RK ORDER CHANG	ES				•
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval ·
								1 Too Mig.	
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes				
	Resolution:		Disposition	: <u></u>	_ QA: N/C C	osed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCF	3)		· · · · · ·	
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B Sign 8		cation	Approval Chief Eng	Approval
		Section A	Chief Eng Chief Eng		Date		ion C	Chief Eng	QC Inspector
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Work Order ID 84900 May-29-12 2:49:39 PM		*84900*					Page				I		
Item ID: Revision ID:	D209-669-04			Accept	*N900	0040	1100) * :	Setup !		*N	S1*	
Item Name:	Replacement S	Skidtube								Stop	*N	S2*	
Start Date:	29/05/2012	Start Qty: 1.00	*1*		Cust Item	ID:							
Required Date:	16/07/2012	Req'd Qty: 1.00	*1*		Customer:								
Reference:													
Approvals:	Process Pla	n:	Date:	Tooling:	D	ate:		I		Start	*N	R1*	
	QC:		Date:	SPC (Y/N):	D	ate:			i	Stop	*N	R2*	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		leject lumber	Insp. Stamp	
200		Pressure Wash per QSI0	05 4.3	0.00			٠	- •				•	
200 HandFinish		Memo		0.00									
Hand Finishing													
210		White Gloss(Ref:4.3.5.1)) per QSI005 4.3-Alum	0.00									
210 Powdercoat		Memo		0.00									
Powder Coating	·	START TIM OVEN TEM	1E: 1PERATURE: 1E:										
220		QC3- Inspect Part Finish		0.00									
22U		Memo		0.00									

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Quality Control

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W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
									,			
												
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes No DQA: Date: _							
		esolution:	Disposition	on: '	QA: N/C C	losed:		Date: _				
NCR:			ER NON-CONFORMA	NCE (NC	R)	·						
DATE	STEP	Description of NC	Initial	Corrective Action Section	n B Sign		cation		Approval			
		Section A	Chief Eng	Action Description Chief Eng	Date		on C	Chief Eng	QC Inspector			
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Work Order ID 84900 May-29-12 2:49:39 PM				*849				. 73	Page			
Item ID: Revision ID:	D209-669-0	43	.a	Accept	*N900	040	100) *	Setup	Start	*N	S1*
Item Name:	Replacement	Skidtube								Stop	*N	S2*
Start Date: Required Date: Reference:	29/05/2012 16/07/2012	Start Qty: 1.00 Req'd Qty: 1.00	•		Cust Item Customer:							
Approvals:	Process Plan:QC:		Date:	Tooling:	Date:				Run Start		"NRT"	
				SPC (Y/N):		Date:				Stop		
Sequence ID/ Work Center II	0	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rejec Qty		Reject Number	Insp. Stamp
230 HandFinish		HandFinishing		0.00								
Hand Finishing		insert holes A/R Sika Sikaflex exp 2-Coat D25 per Dwg D2 3-Inspect fo 4-Install D2	before installing weather 291 bire date: 94-3 O' rings with Po 906 r foreign object per O	per Dwg. D2906. Use a drop of arplates etroleum Jelly and install on D2 QSI 024 as per Dwg D2906 and seal Fw	594-1 plugs as							

A/R Sikaflex-291
Sikaflex expire date:

5-Wing Walk as per Dwg D2906 and QSI 005 4.4 Batch:

	•															
W/O:			WORK ORDER CHANGES													
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval · QC Inspector							
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A :	Date: _								
Resolution		esolution:	Dispositio	n: <u>'</u>	_ QA: N/C (Closed:		Date: _								
NCR:			WORK ORDER NON-CONFORMANCE (NCR)													
DATE	STEP	Description of NC			ion B	Verifi	cation	Approval	Approval							
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ion C	Chief Eng	QC Inspector							
	25-01-17															
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Work	Order ID	84900
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Item ID: Revision ID: Item Name:	D209-669-04 Replacement S		77. (1 <u>4.</u> 4	Accept	*N900	040	1100)* s	Setup Sta	1.71	S1*		
Start Date: Required Date: Reference:	29/05/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:					* ^ N	S2*		
Approvals:		n:		-	D	ate:		F	Run Sta Sto	!/	R1*		
	QC:		Date:	_ SPC (Y/N):	D	ate:			510	* *N	R2*		
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp		
*240 *240* QC Quality Control		QC5- Inspect part comple Memo Inspect Aft C Foreign object	·	0.00 0.00 Walk of work to Current	Step Inspect for						·		
250				0.00									
250 Packaging Packaging		Packaging Memo Identify and Location: PPP Rev:		0.00 PPPD209-669-043									
*260 *260*		QC21- Final Inspection -	Work Order Release	0.00									
QC Quality Control		Memo		0.00					(MIJ Josed	12/08/19 at Ze10		

												
W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval of QC Inspector			
L.,												
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _				
Resolution:		esolution:	Dispositio	n: <u>'</u>	QA: N/C CI	osed:		Date: _				
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	()						
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval			
DAIL	U.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Action Description Sign & Section Chief Eng Date							
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May-29-12 2:49:44 PM

Work Order ID: 84900

84900

Parent Item: D209-669-043 *D209-669-043*

Parent Item Name:

Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

new IPP 08.02.13 LL, verified by: DD

IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1		Manufactured	No		·		Each	81.0000		19			
D4202-1									**				, <u></u>
				Locatio	<u>n</u>	Loc	<u>Oty</u>	Loc Code					
				LG			5		_		_		
					77727		5				_		
				LG002			76		_		_		
					78806		6				_		
D2500-1-190		34 6 . 1	NI.		79810	110	70				_		
	4004	Manufactured	No			110	Each	91.0000	1	1			
D2500-1-1 Ext'n -`I' Beam Tube 4"	190								**	SH	<u>Ŋ</u>	12	66-70
				<u>Locatio</u>	<u>n</u>	Loc	<u>Qty</u>	Loc Code					
				HALL			91						
					74777		14				_		
D2926-3		3.4	N T -		80061		77		_	<u> </u>	-		
		Manufactured	No			110	Each	0.0000	1	1			
D2926-3									**				
D2855		Manufactured	No			230	Each	21.0000	2	2	٠		
D2855	•								**				
Cap				Location	<u>1</u>	Loc (<u>Oty</u>	Loc Code					
				FP002			21	_					
					65519		2				-		
					73347		16				_		
					75074		3				_		

W/O:			W	ORK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval ·
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								:	
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
	Resolution:		Dispositio	n: <u>'</u>	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCI	₹)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector
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Picklist Print May-29-12 2:49:44										Page 2
Work Order ID: 84	900		*84	900*					- · ·	
Parent Item: D2	209-669-043			209-669-0	12*					
Parent Item Name:	Replacement Skidtu	be	1 //	/ ():9-()():9-()	4.)		Star	t Date: 29	9/05/2012	Required Date: 16/07/2012
							Sta	rt Qty: 1.	00	Required Qty: 1.00
AN3-5A		Purchased	No		230	Each	1,090.000	4	4	
*AN3-5A	*						•	**		
				Location	Lo	oc Qty	Loc Code			
				ST350		1090				-
				115371		46				_
				117423		124				_
				118626		31				_
				119355		200				_
				120187		500				_
AN960JD10L	NAS1149D0332J	Purchased	No	121185	230	189	0.0000	4		_
		Purchased	NO		230	Each	0.0000	4	4	
*AN960.1	1)1() *						7	k*		
ALS7-1032-130		Purchased	No		230	Each	2,136.000	44	44	
AI S7-10	132-130						7	* *		

Location Loc Oty Loc Code ST280 ST282

		 							
W/O:			WO	RK ORDER CHANG	ES				•
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval . QC Inspector
		•							
Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	: '	_ QA: N/C C	osed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCF	3)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DAIL	OIL!	Section A	Initial Chief Eng	Action Description Chief Eng	Sign and Date		ion C	Chief Eng	QC Inspector
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Picklist Prin										Page 3
Work Order ID:	84900		*2/	1900*						
Parent Item: Parent Item Name	D209-669-043 Replacement Skidtu	.ho		209-669-(143*					
t at out stem staine	. Replacement Skidte	ioc						t Date: 29 rt Qty: 1.	9/05/2012 00	Required Date: 16/07/2012 Required Qty: 1.00
AN3C4A		Purchased	No		230	Each	1,458.000	44	44	
AN3C4	Α						*	**		
				Location	Lo	oc Qty	Loc Code			
				ST350		1458				
				120187		57				
				120521		28				
				120769		38				
				121205		1000				<u>_</u>
				121556		335				<u>_</u>
AN960C10L	NAS1149C0332 R	Purchased	No		230	Each	0.0000	44	44	
*AN960	C10I *						*	*		
D2594-3		Manufactured	No		230	Each	2 418 000	14	1.4	

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May-29-12 2:49:44 PM

D2594-3 O-Ring, 205 Skidtube

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W/O:		······································	WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval CC Inspector					
														
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _						
		esolution:												
NCR:	., ,		WORK ORD	ER NON-CONFORMA	NCE (NCR)			MA 111					
DATE	STEP	Description of NC		Corrective Action Section		Verification		Approval	Approval					
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	ion C	Chief Eng	QC Inspector					
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Picklist Print May-29-12 2:49:44 PM									<u></u> .	Page 4
Work Order ID: 84900	 - · · · · · · · · · · · · · · · ·	*84	1900)*						
Parent Item: D209-669-043				, -669-(040*					
Parent Item Name: Replacement	Skidtube	1 //	/()9	-ททฺฺฺ	14.5		S+	art Date: 2	0/05/2012	Paguinad Data: 16/07/2012
•								tart Qty: 1		Required Date: 16/07/2012
D2594-1	M 6	N T.			***					Required Qty: 1.00
D2594-1 Plug, 205 Skidtube	Manufactured	No			230	Each	311.0000	14 **	14	• • • • • • • • • • • • • • • • • • • •
<i>G</i> ,			Locatio	<u>n</u>	L	oe Qty	Loc Code			
			FP001			98				
				73401		30				_
				74442		18				_
				79495		50				_
			FP-A	73401		213				
				78590		0 213				
D3564-9	Manufactured	No			230	Each	22.0000	1	1	_
D3564-9 Wearshoe							-2	**		
			Location	<u>n</u>	Lo	oc Qty	Loc Code			
			FG		_	4				
				76950		4				_
			FP001			18				
				67590		4				
				69943 82255		1				_
D3564-11	Manufactured	No		82233	230	13 Each	8.0000	,		_
	Manufactureu	140			230	Each	8.0000		1	
D3564-11 Wearshoe								**		
			Location	<u>1</u>	La	c Qty	Loc Code			
			FG			4				
				77056		4				
			FP001			4				_
				80341		4				_

W/O:			WO	RK ORDER CHANG	FS				
DATE	STEP	PRO	OCEDURE CHAN		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQ	A :	_ Date: _	
	Res	olution:	Disposition	• •	_ QA: N/C CI	osed:	<u> </u>	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	1)			
DATE	STEP	Description of NC	Initial	on B Sign &	Verification Section C			Approval	
		Section A	Chief Eng	Action Description Chief Eng	Date	Secti	on C	Chief Eng	QC Inspector
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May-29-12 2:49:44 PM

Work Order ID: 84900

84900

Parent Item:

D209-669-043

Parent Item Name: Replacement Skidtube

D209-669-043

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured

Manufactured

No

230

Each

13.0000

**

Loc Qty Location Loc Code FG 2 34806 2 FP001 11 77609 3 82254 8 Manufactured 230 Each 31.0000 2 2 **

Each

D3566-1

D3566-1

Gasket

D3566-5

Location Loc Qty Loc Code FP -22 81619 10 FP002 53 68924 2 80919 3 83898 16

80374

82274

21.0000 **

D3566-5 Gasket

> Location Loc Qty Loc Code FP 12 82275 12 FP002 9

230

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		WO	RK ORDER CHANG	GES		·			b
STEP	PRO	OCEDURE CHAN	IGE	В	у	Approval Chief Eng / Prod Mgr Approv QC Inspec			
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	A.1								
		lo DQ	A:	_ Date: _					
Re	esolution:	Disposition	, , , , , , , , , , , , , , , , , , ,			sed:		Date: _	
		WORK ORDE	R NON-CONFORM	ANCE (I	NCR)				
STED	Description of NC						cation	Approval	Approval
Jili	Section A	Initial Chief Eng	Action Description Chief Eng			Secti	on C	Chief Eng	QC Inspector
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		:PAR #: Resolution: STED Description of NC	STEP PROCEDURE CHAN PAR #: Fault Categ Resolution: Disposition WORK ORDE STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORM STEP Description of NC Section A Corrective Action Section A Corrective Action Description	PAR #: Fault Category: NCR: \ Resolution: Disposition: QA: N/ WORK ORDER NON-CONFORMANCE (NOTE OF THE NOTE OF THE N	STEP PROCEDURE CHANGE By PROCEDURE CHANGE By Fault Category: NCR: Yes N Resolution: Disposition: QA: N/C Clos WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Corrective Action Section B Step Initial Action Description Sign &	STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr :PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC

2 &	QTY -043	Part Number	Description
×		D2906-041	SKIDTUBE ASSEMBLY
	×	D2906-043	SKIDTUBE ASSEMBLY
-	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1		D2926-1	WEB
	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	-	D3564-5	WEARSHOE (REPLACES D2577-5)
1		D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1		D3566-15	GASKET
20	44	ALS7-1032-130	INSERT
		or AKS7-1032-130 or AKS4-1032-130	
		or ALS4-1032-130	
50	44	AN3C4A	BOLT
4	4	AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960JD10L	WASHER

GENERAL NOTES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY **RETURN TO** ENGINEERING **UNCONTROLLED COPY**

SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER 0. <u>84900 M</u>L

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1) CLEARANCES ARE TEN LOAD SING ONLESS OF DENVISE NOTES.
2) LENGTH OF DS500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
3) INSERT D2926-1-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND CONTROL D2926-1-3 WEB TO LOCATION STRUCTURAL SIKAFLEX-241/291

ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF CONTROL OF 0.200
IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM REDUCTION OF 0.200
IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
6) AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200
IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
6) USE DART DRILL ZO0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3CAA BOLTS AND ANGOC10L WASHERS WITH SIKAFLEX-241/291.
7) WELDING TO BE DONE PER DART QSI 004. 6

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ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4 INSERT D2594-1 PLUG CW D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).

RELEASED

07.04.04

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DATE	ВУ	DESCRIPTION	Ω		REV.
04.06.22	<u>о</u>		SSUE	NEW ISSUE	٨
07.08.21	80	PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP PIN: PG 3 D7: 38 PLACES WAS 44 PLACES;	CHANGE WEARPLAT CHANGE WEARPLAT PG 1: ADD NOTE 10; PG 2 C7: REMOVE AF PG 3 C3: CORRECTEI PG 3 D7: 38 PLACES	ADD S CHANC PG 1: A PG 3 C PG 3 C	Δ

NTS

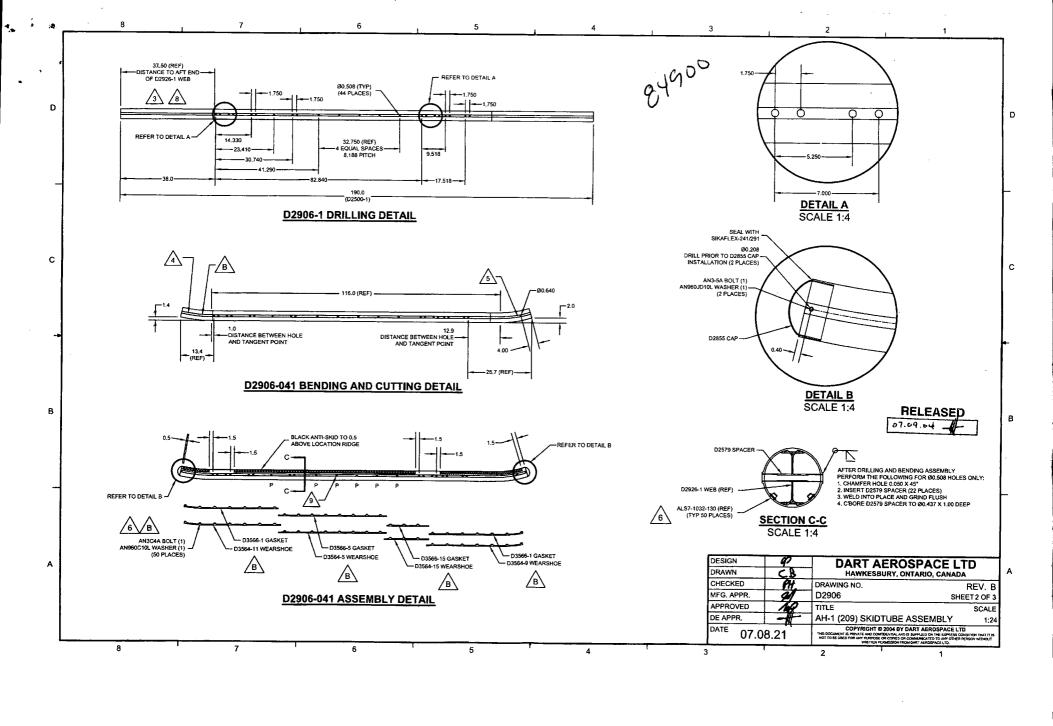
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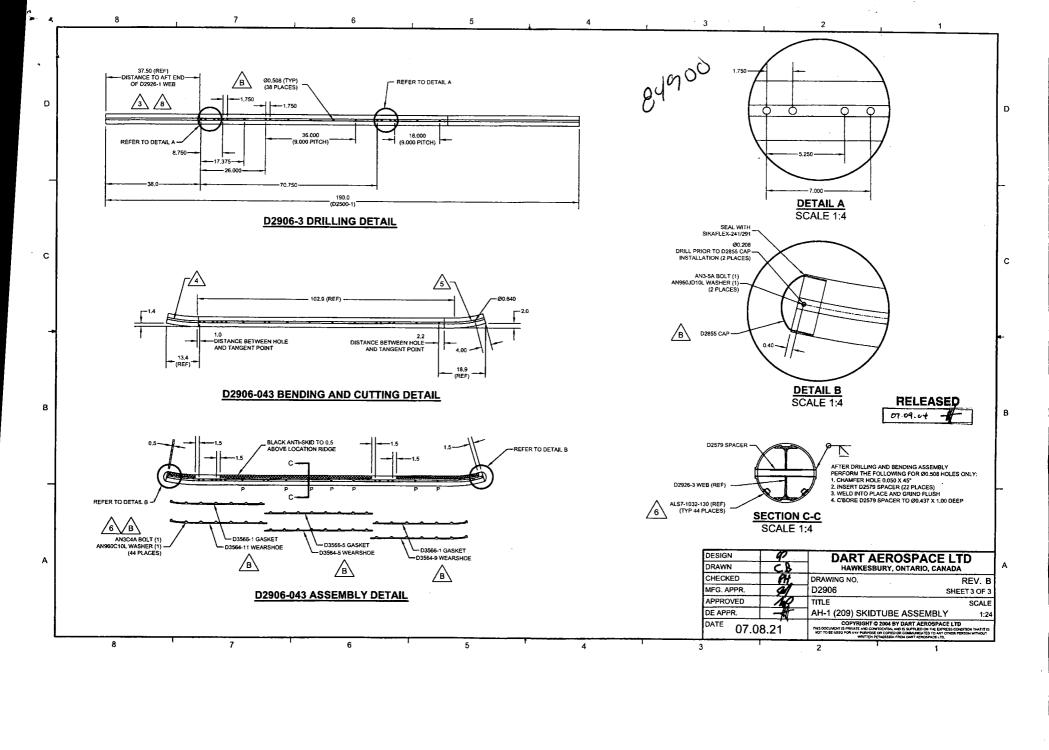
AH-1 (209) SKIDTUBE ASSEMBLY

W/O:			W	ORK ORDER CHANG	ES			
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DATE STEP		Description of NC		Corrective Action Secti		Verification	Approval	Approval
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W/O:			W	ORK ORDER CHANG	ES	<u></u>		
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Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes	No DQA:	Date: _	
Resolution: Disposition				on:	_ QA: N/C Clo	sed:	Date: _	
NCR:		W	ORK ORE	DER NON-CONFORMA	NCE (NCR)		
DATE STEP		Description of NC	Corrective Action Section I			Verification	n Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Dart Aerospa	ace Ltd
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W/O:			V	ORK ORDER CHANGI	ES				•
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NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section			cation	Approval	Approval
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